

# Work Order ID 73534

Thursday, September 01, 2011 3:10:01 PM

Page 1

Item ID: D3189-1

Accept

Revision ID:

Item Name: Chafing Shield

Start Date: 9/1/2011 Start Qty: 20.00

Required Date: 9/9/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3189

Rev B

100

0.00



Waterjet

SHEAR

Memo

0.00

FLOW CNC Waterjet

304, G2E

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

103

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-9-19

(24)

B11-9-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73534

Thursday, September 01, 2011 3:10:01 PM



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Item ID: D3189-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Chafing Shield

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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105

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr & Grind Rads as per Dwg D3189  
2-Roll as per Dwg D3189  
3-Apply a thin layer of Pro Seal on inside surface of chafing shield 0.03" - 0.06" thick as per DSI9549 and DEO D412-664-243.

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/02/19

SB 11/09/28

8/11/09/24

100%  
724

240

100%  
724

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 73534

Thursday, September 01, 2011 3:10:01 PM

Page 3

Item ID: D3189-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Chafing Shield

Start Date: 9/1/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: *X-tube*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/10/5*  
*MAF 11-10-4*

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 01, 2011 3:09:58 PM

Page 1

Work Order ID: 73534



Parent Item: D3189-1

Parent Item Name: Chafing Shield

Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP B 05.08.22: No longer made in-house! KJ/JLM  
IPP Rev:C 06-03-24 Rolling Now made in House JLM  
IPP Rev:D 07-04-16 As per Rev B JLM  
11.05.11 now made on waterjet DD verf:JLM

IPP Rev:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S25GA

Purchased

No

100

sf

117.5000

0.32

6.736842



304/316 .020" Sheet



B11-9-19

## Location

## Loc Qty

## Loc Code

MAT20

117.5

117285

5.5

118228

112

118228

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**DART**

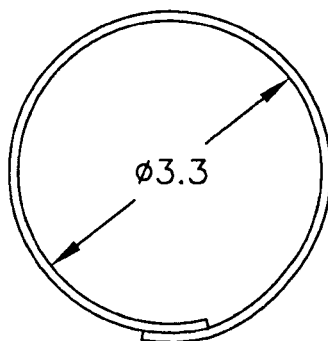
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

**RELEASED**

07 03 27 [Signature]

11.25

4.13

D3189-1 FLAT PATTERNR0.063  
(TYP)D3189-1 ROLLING DETAIL  
NOT TO SCALE

W023534

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

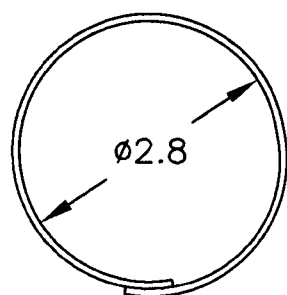
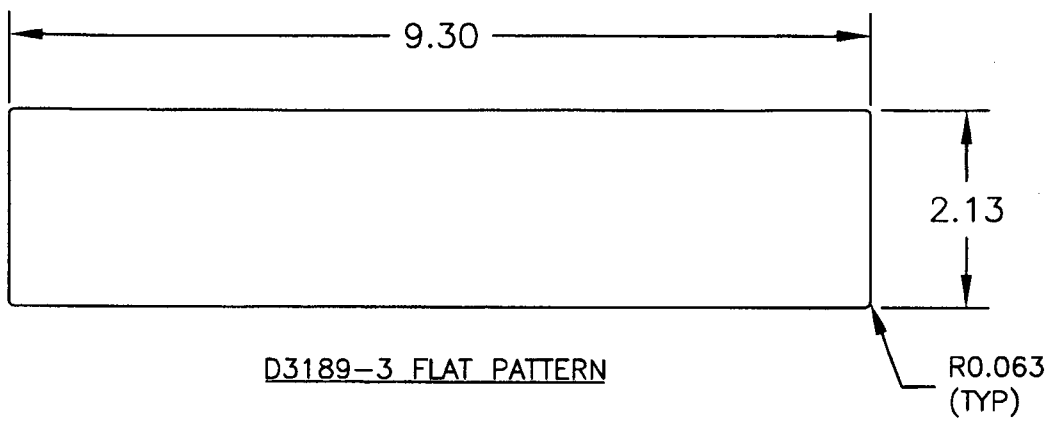
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DESIGN 92	DRAWN BY 92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED  
07.03.27 [Signature]



D3189-3 ROLLING DETAIL  
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

73534

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